



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3407-5

Job Sheet 183638



Part No: D3407-5

Job Qty: 20 ea ²⁴ ^{DAS} ²¹ ⁹⁻⁰⁹

Part Name: Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 9/28/18

Created By: Shannon Hadley

Type: Stock

Description:

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	20 pcs	9/28/18	9/28/18	0.03	1.83	Waterjet 1		ac 18/09/23
110	QC	20 pcs	9/28/18	9/28/18	0.00	0.00	QC2		ac 18/09/23
115	Lathe Conv	20 pcs	9/28/18	9/28/18	0.00	1.32	Lathe Conv-1		ST/ 18/10/10
117	QC	20 pcs	9/28/18	9/28/18	0.00	0.00	QC2		"
120	QC	20 pcs	9/28/18	9/28/18	0.00	0.00	QC8		A.A 18-10-12
130	Packaging	20 pcs	9/28/18	9/28/18	0.00	0.00	Packaging3		21 17
140	QC21-SA	20 Ea	9/28/18	9/28/18	0.00	0.00	QC21		21 17 OCT 15 2018

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: _____ Prog Rev: _____ 2-Break edges on manual lathe Dwg D3407
Descriptions: (175rpm)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-B0.250X4.000	17-4 SS H900 Bar 0.250" X 04.000"	5.3200 ft (.266 ea)	100-Waterjet	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M17-4-H900-B0.250X4.000	5	38	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches $\pm$ 0.010	0.260 0.240		
2	Tow Ring	3.000inches $\pm$ 0.030	3.030 2.970		
3	Tow Ring	2.050inches $\pm$ 0.012 - 0.001	2.062 2.049		
4	Tow Ring	0.750inches $\pm$ 0.030	0.780 0.720		

M17-4-H900-B0.250X4.000
S088679

Plex 9/21/18 3:33 PM Dart.Hadley.Shannon



Container No: S112813



Part: D3407-5

Job No: 183638

Serial No/Batch: S112813

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/24/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3407-5**Job Sheet 183358****Part No:** D3407-5**Job Qty:** 20 ea**Part Name:** Ring**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 9/17/18**Job Tracking No:****Due Date:** 9/28/18**Created By:** Michelle Gagnon-Donovan**Type:** Stock**Description:**

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		9/28/18	0.00	0.00	Start Up Waterjet		
100	Waterjet	20 pcs		9/28/18	0.03	1.83	Waterjet1		
110	QC	20 pcs		9/28/18	0.00	0.00	QC2		
115	Lathe Conv	20 pcs		9/28/18	0.00	1.32	Lathe Conv-1		
117	QC	20 pcs		9/28/18	0.00	0.00	QC2		
120	QC	20 pcs		9/28/18	0.00	0.00	QC8		
130	Packaging	20 pcs		9/28/18	0.00	0.00	Packaging3		
140	QC21-SA	20 Ea		9/28/18	0.00	0.00	QC21		

Part Op **100** - 1-Cut as per Dwg D3407 Dwg Rev: _____ Prog Rev: _____ 2-Break edges on manual lathe Dwg D3407
Descriptions: (175rpm)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-B0.250X4.000	17-4 SS H900 Bar 0.250" X 04.000"	5.3200 ft (.266 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-B0.250X4.000	5	38	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches ± 0.010	0.260 0.240		
2	Tow Ring	3.000inches ± 0.030	3.030 2.970		
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049		
4	Tow Ring	0.750inches ± 0.030	0.780 0.720		

Plex 9/17/18 10:12 AM Dart.Gagnon.Michelle

